

Work Order ID 131149

March-26-15 1:45:27 PM

649.5210
B131149
REV: A

131149

Page 1

Item ID: 649.5210

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler

Start Date: 3/28/15 Start Qty: 5.00

5

Cust Item ID:

Required Date: 3/28/15 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLS Date: 15-03-31

Tooling:

Date:

Run Start *NR1*

QC: Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

649.5200

A

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

7 02/15/04/06

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

7 02/15/04/06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
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Unapproved									

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Work Order ID 131149

131149

Page 4

March-26-15 1:45:27 PM

Item ID: 649.5210 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 3/28/15 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 3/28/15 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: ECK125 CCK023A Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***	0.00 0.00		DAS 6 9-89		7	10		MAY 04 2015
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					ML5		MAY 05 2015

ML5 MAY 05 2015

DQA: _____ Date: _____



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Equip/Tooling									
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Picklist Print

March-26-15 1:45:26 PM

Page 1

Work Order ID: 131149

131149

Parent Item: 649.5210

649 5210

Parent Item Name: Doubler

Start Date: 3/28/15

Required Date: 3/28/15

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 13.01.10 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.125		Purchased	No			110	sf	45.0000	0.06	0.31579			

M2024T3S 125

DU 15/04/06

2024-T3 .125 sheet

Location

Loc Qty

Loc Code

MAT021

45

M127668

45

.5

DQA: _____ Date: _____



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DART AEROSPACE LTD	Work Order:	131149
Description: Doubler	Part Number:	649.5210
Inspection Dwg: 649.5200 Rev: A		Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:	DC	Checked by:	38	QC Inspector:	
Date:	15/04/06	Date:	APR 06 2015	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03696				SHEET 1 OF 1	
	DWG NO. 649.5200	REV: A	PREPARED BY B. PETERS	DATE: 11/14/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: BRACKET					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: ADDED ALTERNATE MATERIAL.				ECR: D-12-004	

SHEET 1, ZONE A2 IS:

IS

⚠ MATERIAL: 7075-T651 ALUMINUM PER AMS-QQ-A-250/12.

131149 ML5
1503-31

IS

- ⚠ ALTERNATE MATERIAL: 0.125 INCH THICK 2024-T3 ALUMINUM SHEET METAL.
- ⚠ ALTERNATE MATERIAL: 7075-T6511 ALUMINUM PER AMS-QQ-A-200/11.

SHEET 1, ZONE B1 IS:

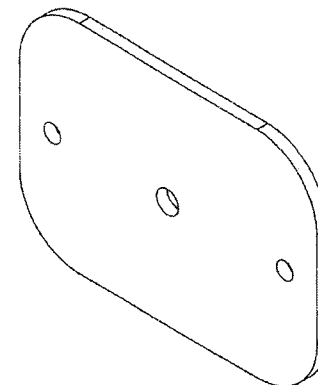
5	R	649.5214		BRACKET	⚠ ⚠	⚠ ⚠
4	R	649.5213		DOUBLER	⚠ ⚠	⚠
3	R	649.5212		BRACKET	⚠ ⚠	⚠ ⚠
2	R	649.5211		SHIM	⚠ ⚠	⚠
1	R	649.5210		DOUBLER	⚠ ⚠	⚠
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:					CHANGE CATEGORY	DER REVIEW REQUIRED
☐ RFMS ☐ MDL ☐ INSTALL INSTRUCC ☐ ICA ☒ BOM					☐ MAJOR ☒ MINOR	☐ YES ☒ NO

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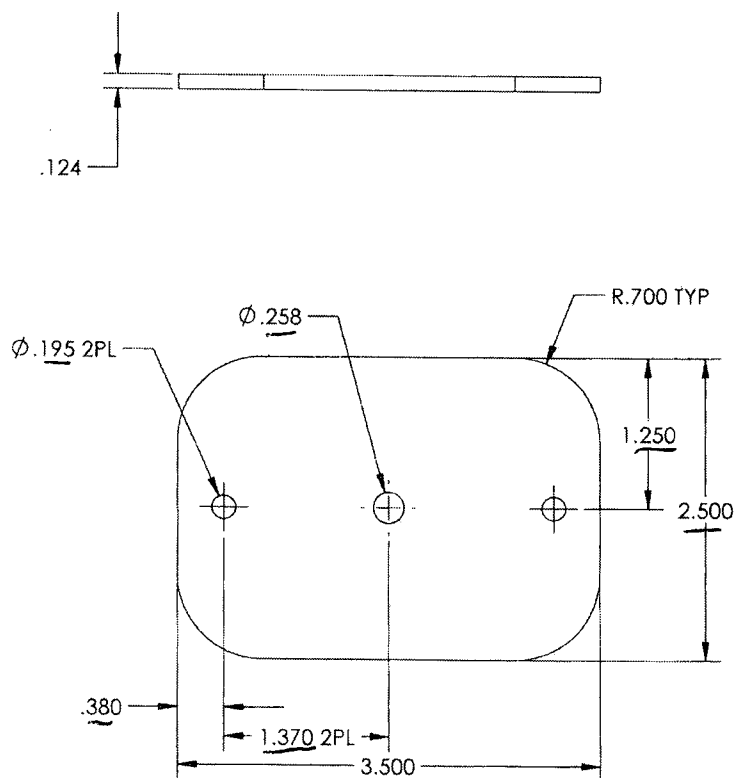
NOTES: UNLESS OTHERWISE SPECIFIED

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR: BLACK; PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J TYPE I, CLASS N.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120. LASER ENGRAVE CENTURY GOTHIC, 12 POINT P/N AND REVISION.
- 5 PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: 649.5212 BRACKET.SLDPRG, LAST MODIFIED 11-02-11.
- 6 PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: 649.5214 BRACKET.SLDPRG, LAST MODIFIED 11-02-11.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PR1		N/A
N/C	INITIAL RELEASE	11-02-11	P. BRAVO
A	INCORPORATED ECN 03408	04-17-12	P. BRAVO



649.5210



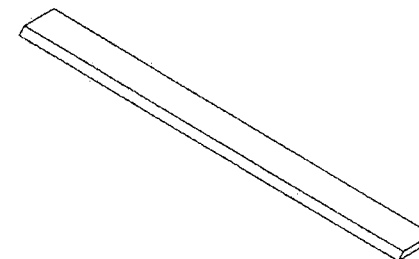
UNINCORPORATED ECN(s)

036096

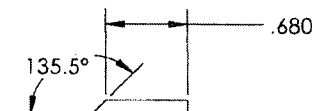
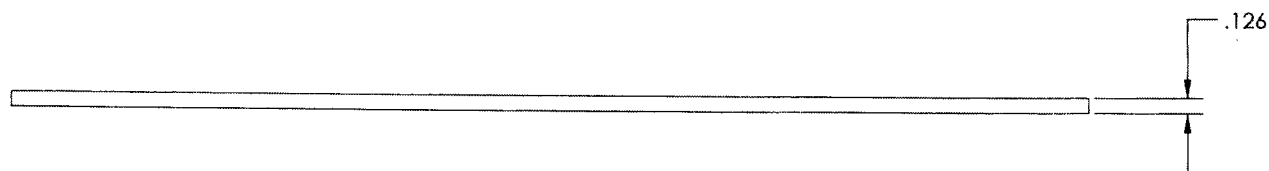
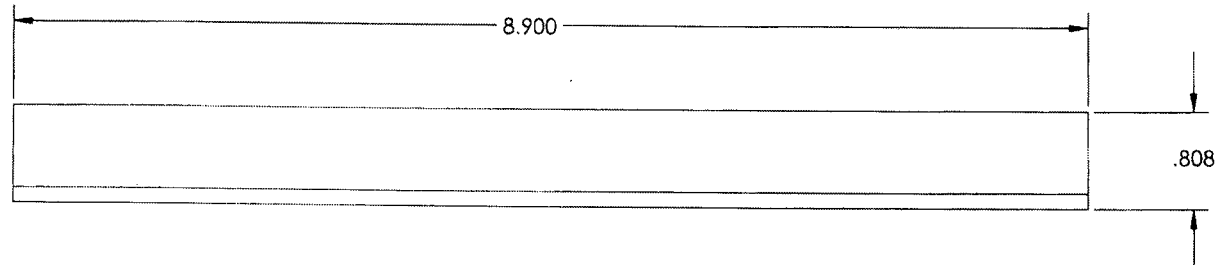
	5	649.5214	BRACKET	△	△△△
	4	649.5213	DOUBLER	△	△
	3	649.5212	BRACKET	△	△△△
	2	649.5211	SHIM	△	△
	1	649.5210	DOUBLER	△	△
	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY			PARTS LIST		
NEXT ASSY (S)			APICAL INDUSTRIES		
649.4700			2608 TEMPLE HEIGHTS DR.		
			OCEANSIDE, CA. 92056-3512 (760) 724-5300		
			BRACKET		
			UNLESS OTHERWISE SPECIFIED		
			DIMENSIONS ARE IN INCHES		
			TOLERANCES ARE:		
			2 PLACE DECIMALS ± .01		
			3 PLACE DECIMALS ± .005		
			ANGLES ± .5°		
			SCALE NONE		
			SHEET 1 OF 4		

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



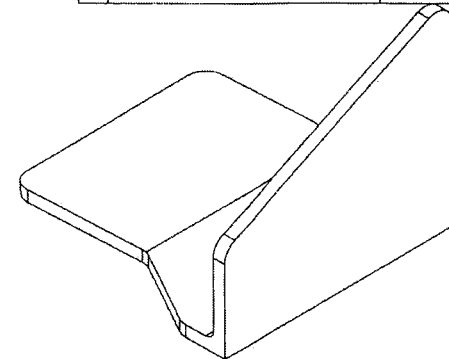
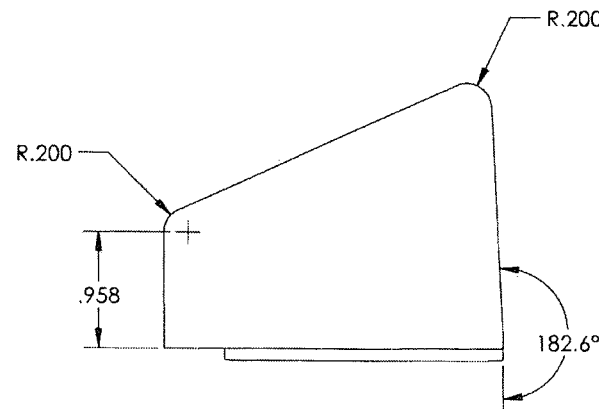
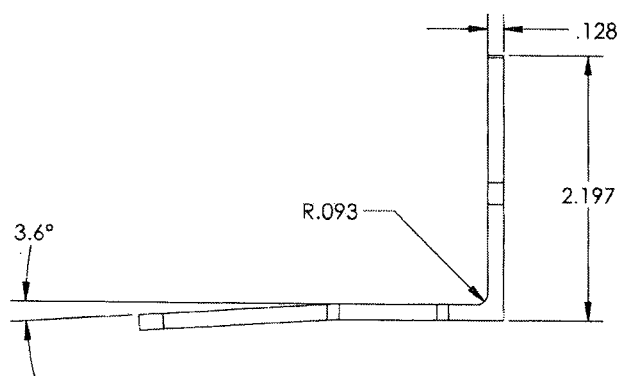
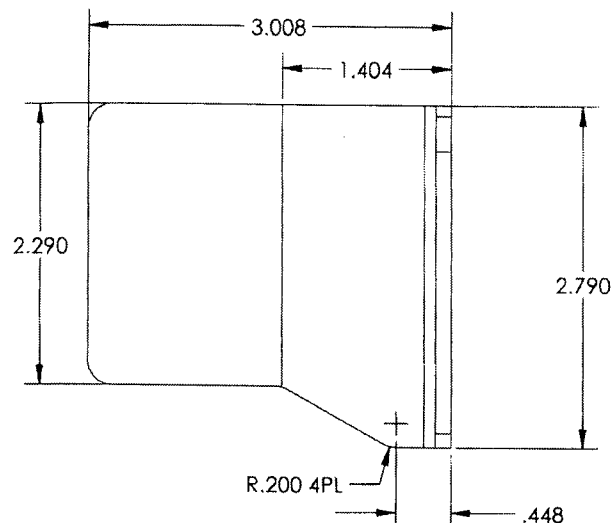
649.5211



ORIGINAL DATE (MM-DD-YY) 11-07-11		APICAL INDUSTRIES	
DRAWN BY A. CULAN	CHECKED P. BRAVO	2408 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAVO 11-07-11		BRACKET	
CONTRACT NO.		REV. A	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ± .01 ANGLES ± .5°		SCALE NONE	SHEET 2 OF 4

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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

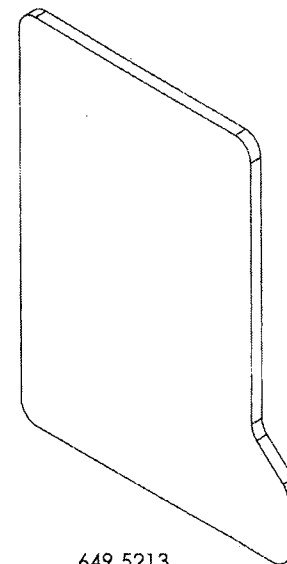
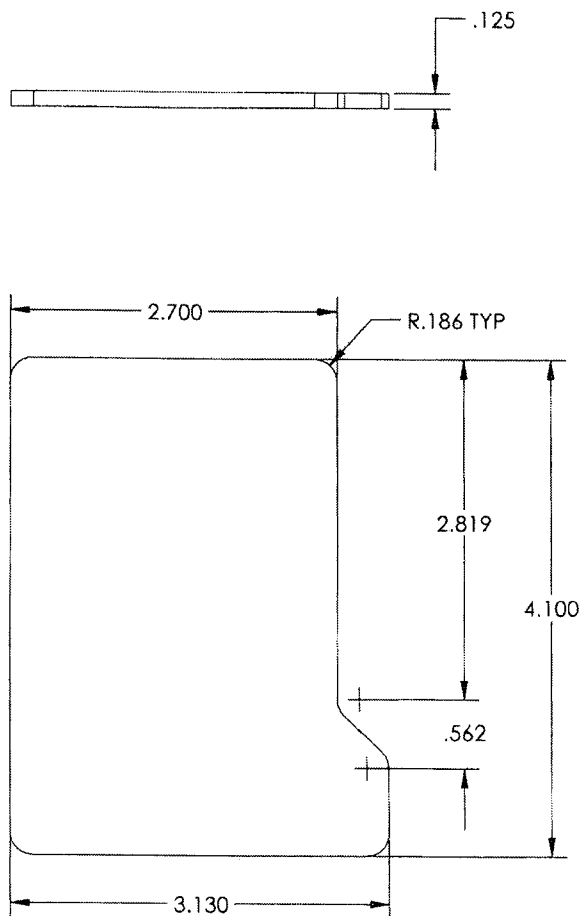


649.5212 SHOWN
649.5214 OPPOSITE

ORIGINAL DATE (MM-DD-YY) 11-02-11		APICAL INDUSTRIES	
DRAWN BY A. QUINN	CHECKER P. BRAVO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL (SIGNATURE)		BRACKET	
CONTRACT NO.		649.5200	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ±.01 ANGLES ±.5°		SHEET 3 OF 4	REV. A

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



649.5213

ORIGINAL DATE 11-02-11		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY A. OLSEN	CHECKED P. BRAYNO		
DRAWING APPROVAL P. BRAYNO 11-02-11 CONTRACTING		BRACKET	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET B	REV A
SCALE NONE		DWG NO 649.5200	SHEET 4 OF 4



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27987**

Purchase Order Date 4/1/2015
PO Print Date 4/16/2015

Page Number 6 of 8

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

16	131150	649.4812 SHIM REV. A	4/24/2015	8.00	\$12.15	\$97.20
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Yes

4/24/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$97.20

17	131033	649.4814 DOUBLER REV. A	4/24/2015	6.00	\$6.25	\$37.50
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Yes

4/24/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$37.50

18	131149	649.5210 DOUBLER REV. A	4/24/2015	7.00	\$7.40	\$51.80
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Yes

4/24/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total: \$51.80

Note:

4/16/2015



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63666

Date: 24-Apr-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
	PRIME MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLY BY CUSTOMER Job: 20150305 PO: PO27987 Line:		
8 ea	Part: 649.4812 SHIM HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLY BY CUSTOMER Job: 20150306 PO: PO27987 Line:	Rev: A	
6 ea	Part: 649.4814 DOUBLER HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLY BY CUSTOMER Job: 20150307 PO: PO27987 Line:	Rev: A	
7 ea	Part: 649.5210 DOUBLER HARD ANODIZE BLACK TYPE III CLASS 2 PRIME PER MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLIED BY CUSTOMER Job: 20150308 PO: PO27987 Line:	Rev: A <i>SP15-04-24.</i>	
6 ea	Part: 649.5213 DOUBLER HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLY BY CUSTOMER	Rev: A	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63666

Date: 24-Apr-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
	Job: 20150309 PO: PO27987 Line:		
2 ea	Part: D4703-043 Rev: A LOCK PIN HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20150310 PO: PO27987 Line:		
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE : <u>24/4/15</u> CERTIFIED SIGNATURE : <u></u> RECEIVER SIGNATURE : _____			